

Work Order ID 56089

February 10, 2010 12:11:55 PM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

(4)

Stop



Start Date: 2/10/10 Start Qty: 5.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: *RL*

Date: 10-2-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

002

Handwritten: 10/03/03

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

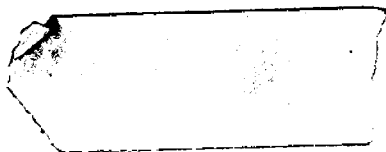
2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *m110130*

3-Grind End Plate flush *m11311*

Handwritten: 10.02.24 5

Handwritten: All, melanie



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

x5

BE 02/24

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/24

x5
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-02-24

5

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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

H

10/02/25

X5

Ø

Memo

0.00

180



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

1-Assemble Leg Assembly as per Dwg D3272.

H

2-Leave one rivet out until welding is complete.

H

3-Bevel Aft end for welding

H

4-Inspect for foreign object as per QSI 024

H

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

H

A/R □ Aluminum Rod □ m111311

6-Grind End Plate flush

H

7-Install last rivet as per Dwg.

H

H 10.02.25

5

Ø

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Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(5)

10.02.26

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sister be

(5)
RHC

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

uf 10/03/03

(X5R14) Ø

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Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description PRESSURE WASH

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30AM

⇒ JU

10/03/03

(X5134) Ø

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

BK-10-03-3

(5 RH)

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 10/03/04

(X4 RH)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270		0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>NW B</u>								

10-3-4 SP 140

8/10/03/04

14
124

10/3/10 14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 *[Signature]*

ME
10-3-05

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 56089

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

D3065-041 Manufactured No

Each 60.0000 5.0000



10.02.25

Step Leg Assembly Hi

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

60

53795

30

55450

30

5

D3066-1 Manufactured No

Each 42.0000 10.0000



10.02.25

Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42

51545

11

53783

31

10

D3219-1 Manufactured No

Each 62.0000 10.0000



10.02.24

Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

62

53789

62

10

W/O:		WORK ORDER CHANGES					
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Start Qty: 5.00

Required Qty: 5.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

D3067-1 Manufactured No 110 Each 53.0000 5.0000



10-02-24

End Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

53

53784

53

5

D3272-1 Manufactured No 110 Each 0.0000 5.0000



10-02-24 356091

Step

MS21042LS

02

Purchased No 110 Each 459.0000 10.0000



10-3-4 54 10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

458

110382

10

111636

1

112314

20

113523

227

113537

200

8

Main Warehouse

ST139

1

112314

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

MS20600-AD4W4

Purchased

No

180

Each

1,203.000 80.0000



12.02.25

Rivets

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1203

110731

215

111359

46

111477

74

112314

344

112385

24

113368

500

80

AM3-354

Purchased

No

260

Each

201.0000 10.0000



10-3-4

sl (4)

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

106993

12

110467

1

112314

188

8

W/O:		WORK ORDER CHANGES					
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IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

AN413A X8
Bolt

Purchased No 260 Each 269.0000 40.0000

10-3-4 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 269

113359 69

113749 200

17406 0

51764 0

1
32

AN5-36A X2
Bolt

Purchased No 260 Each 115.0000 10.0000

10-3-4 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 115

109545 11

110467 7

110731 4

112243 20

112314 23

112385 50

8

OSI OIM SP
NAS114900363-J X4
AN960JD10
Washer

Purchased No 260 Each 0.0000 20.0000

1113288 10-3-4 SP

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Page 4

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IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

AN960JD416	Washer	Purchased	No	260	Each	0.0000	80.0000
AN960JD516	Washer	Purchased	No	260	Each	0.0000	20.0000
D2230-3	Lug	Manufactured	No	260	Each	13.0000	20.0000

M113706 10-3-4

M113524 10-3-4

B55310 10-3-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST176

5

53881

5

Main Warehouse

ST476

1

53781

1

4K

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IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:c

S
H



Bushing

Manufactured No 260 Each 61.0000 10.0000



10-3-4 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

61

50989

61

8



Abraison Strip

Manufactured No

260

f

264.9521

3.0000



10-3-4 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

264.9520842

50593

141.312084

52563

123.64

2x4

D3067-1



End Plate

Manufactured No

260

Each

53.0000

5.0000



10-02-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

53784

53

5

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IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

83235-1
84
Mounting Lug

Manufactured No 260 Each 47.0000 10.0000



10-3-3 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 47

45398 4

54756 43

8

83278-041
84
Support Assembly

Manufactured No 260 Each 63.0000 5.0000



10-3-3 SP (4x)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 23

53227 23

Main Warehouse

ST471 40

55318 40

4

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Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

MS21042L3

Purchased

No

260

Each

2,681.000 10.0000



10-3-3

SL

(40)

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2675

110844

35

111274

27

111668

52

112314

289

112385

498

113523

74

113537

700

113644

1000

Main Warehouse

ST139

6

111668

6

February 10, 2010 12:11:59 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

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Work Order ID: 56089



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

MS21042L4

Purchased

No

260

Each

2,535.000

40.0000



10-3-3 sf

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2535

102552

6

104248

6

110507

184

111827

1339

113422

1000

15924

0

32

46
sf

February 10, 2010 12:11:59 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *54089*
BJ10-2-10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

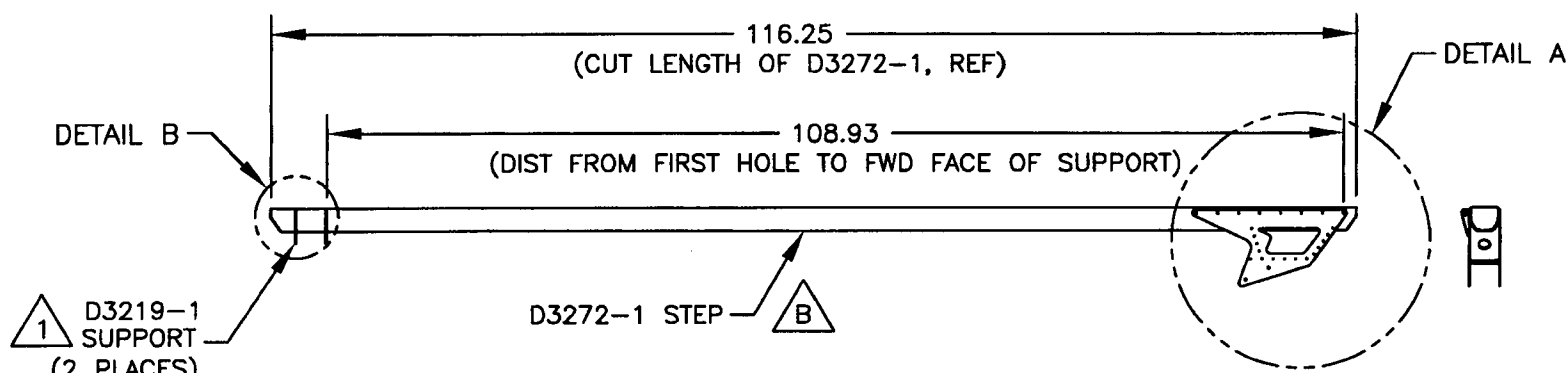
NOTE: Date & initial all entries



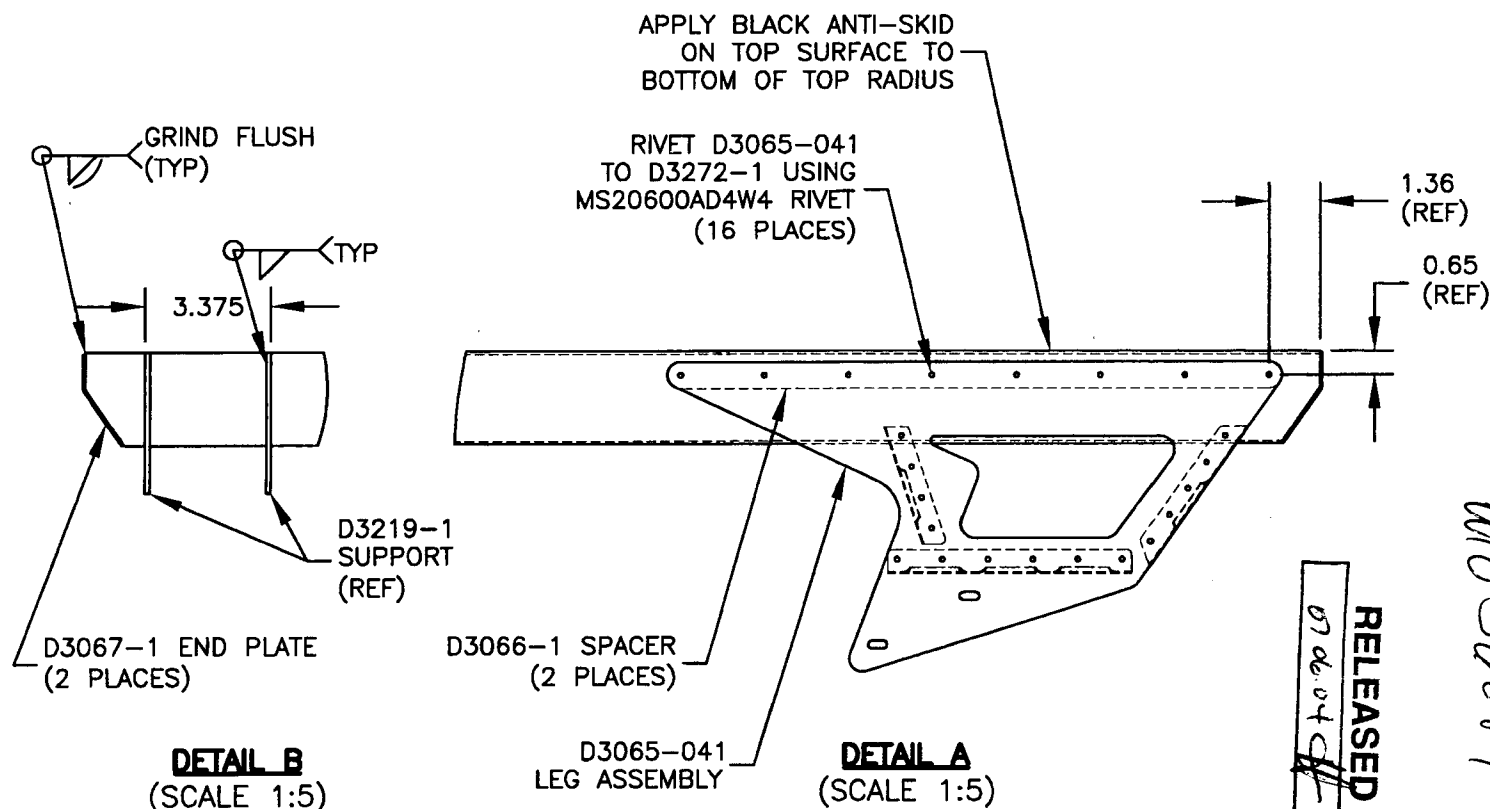
DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	

W/O 56089

RELEASED
07.06.04



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

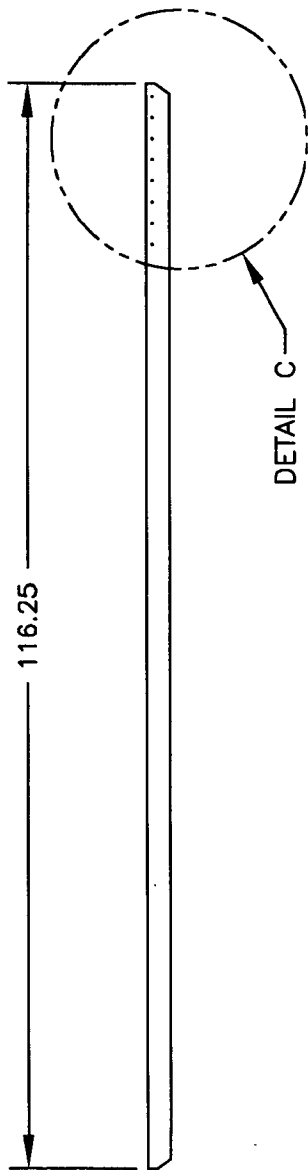


DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

w/o 56089

RELEASED

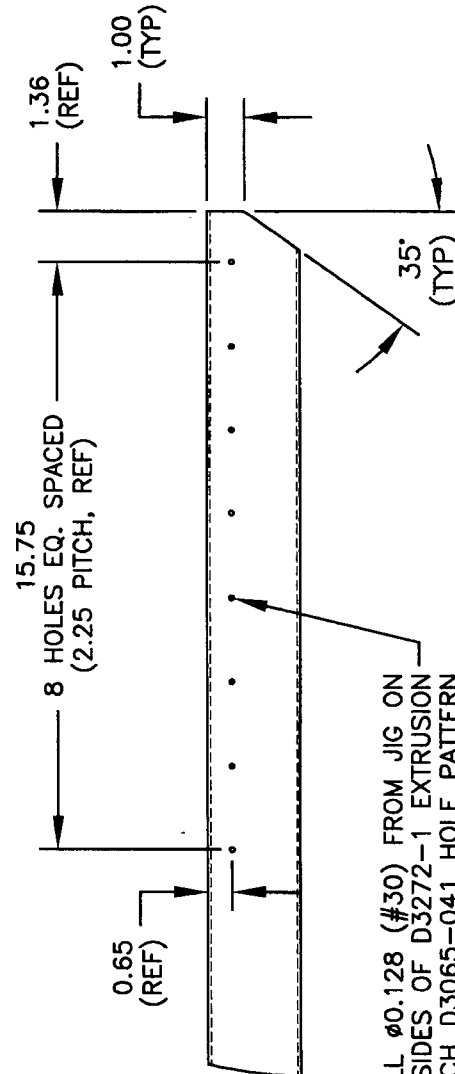
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

C DETAIL C

(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011, Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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